

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004253**Date Inspected:** 26-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang, Zhi Neng Zhang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 89M tower mockup, tower skin assemblies, etc.**Summary of Items Observed:**

89M Tower Mockup

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) observed no welding being performed. The fit lug to diaphragm area was at ambient temperature.

Tower shop - Bay 1

QA Inspector randomly observed approximately 65 ZPMC workers performing the following: flame heat straightening of stiffeners and skin plates; air-arc-ing into the cover pass on SSD1 – skin E lap assembly; two ZPMC UT technicians preparing to perform UT on stiffener to skin plate welds on SSD1 – skin D lap assembly; FCAW-G fill pass on SSD1 – skin A lap assembly; grinding of SAW root pass on weld SSD1-SA61A/G-17A; flame heat straightening and grinding of cover passes and 70mm x 150mm half-round holes in stiffeners on SSD1-D skin assembly; grinding of cover passes of stiffeners to skin plates on SSD1-D skin assembly; FCAW-G of stiffener butt welds. Also present in this bay were ZPMC CWI's Li Yang, Zhi Neng Zhang, and CAWI Zhang Huang as well as ABF QC's Jiang Zi Wen, Yang Yi Heng and Zhang Qing Jian. Items observed appeared to comply with project specifications.

Tower shop - Bay 2

QA Inspector randomly observed approximately 55 ZPMC workers performing the following: flame heat straightening of ESD1-skin B plate only; SMAW of indications on stiffeners on ESD1-skin D assembly. QA Inspector and QA Inspector Greg Bertlesman (QA Inspector 2) were again assigned, as on the previous day, by QA Task Leader Robert Cuellar to perform final MT and VT on the longitudinal stiffener to skin plate welds on ESD1-skin A assembly. Upon arrival at the ESD1-skin A assembly, QA Inspector was informed by ABF QC Don

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Walton that ABF had no record of QC final MT or VT having been performed. Also present in this bay were ABF QC's Zhang Da Ming and Xing Xiao Guang. Items observed appeared to comply with project specifications.

Heavy Duty Machine Shop - Bay 3

QA Inspector randomly observed 2 ZPMC workers in this bay. There were 12 full size panels and several unidentified deck plates in various stages of butt welding present in the bay. It appeared to QA Inspector that ZPMC personnel were grinding deck plate weld repairs performed the previous day per Welding Repair Report B-WR955. Items observed appeared to comply with project specifications.

Summary of Conversations:

As noted above in Summary.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
